

Date: Tuesday, 12/5/2006 8:13:10 AM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : X-TUBE AS 350/355 HI AFT
Job Number : 29765A	
Estimate Number : 12483	
P.O. Number :	Part Number : D350748241
This Issue : 12/5/2006 S.O. No. :	Drawing Number : D350-748-241
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : LANDING GEAR	Drawing Revision : C UNDER REVIEW D
Previous Run : 29764A	Material :
Written By :	Due Date : 1/30/2007 Qty: 1 Um: Each
Checked & Approved By : <u>061205</u>	
Comment : Est Rev: A New Issue 06-07-05 JLM Est Rev: B Update cadplate process 06-09-12 KJ	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	DC	DOCUMENT CONTROL
-----	----	------------------

**Comment:** DOCUMENT CONTROL

Photocopy bluefile and create labels as per PPP D350-748-241 CHG001

2.0	D6018125	Crosstube Material
-----	----------	--------------------

**Comment:** Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Crosstube Material

D6018-125

2.299" OD X 2.000" ID

Batch: 27472

3.0	MORI SEIKI	MORI SEIKI CNC LATHE LARGE
-----	------------	----------------------------

**Comment:** MORI SEIKI CNC LATHE LARGE

1-Fill tube with sand & install plugs on both ends as per Folio FA647

2-Turn first side as per Folio FA647

3-Deburr & Inspect for surface damage. Repair damage within limits as per Dwg D350-748-241

4.0	QC1	INSPECT ALL DIM TO DIM SHEET
-----	-----	------------------------------

**Comment:** INSPECT ALL DIM TO DIM SHEET

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: X-TUBE AS 350/355 HI AFT

Job Number: 29765A

Part Number: D350748241

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

MORI SEIKI

MORI SEIKI CNC LATHE LARGE



Comment: MORI SEIKI CNC LATHE LARGE

1-Turn second side as per Folio FA647

2-Deburr & Inspect for surface damage. Repair damage within limits as per Dwg D350-748-241.

3-Scribe part # as per Dwg D350-748-241

SG 06.12.08

6.0

QC1

INSPECT ALL DIM TO DIM SHEET



Comment: INSPECT ALL DIM TO DIM SHEET

SG 06.12.08

7.0

QC8

SECOND CHECK



Comment: SECOND CHECK

J.G 06/12/08

8.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

Remove all Machining Marks

PMC/JP

66/12/13

①

9.0

OUTSIDE SERVICE

OUTSIDE SERVICES



Comment: Sub-Contracting OUTSIDE SERVICES

Issue P/O: 2725

Heat Treat to min 180 KSI As per Dwg D350-748-241

Sand Blast tube after Heat Treat

Possible Supplier: Vac Aero

Ensure Certificate of Conformity is attached

C 206/12/15

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Receive & Inspect For Transit Damage

Ensure certificate of conformaty is attached

SG 7/1/12

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Process Sheet

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Drawing Name: X-TUBE AS 350/355 HI AFT

Job Number: 29765A

Part Number: D350748241

Job Number:



Seq. #:

Machine Or Operation:

Description :

11.0

QC6

DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

07/04/29

12.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1
Oil inside of tube with LPS-3.

A/R

LPS-3

Batch:

M103 581

EL 7-3-15

13.0

BENDING

BENDING MACHINE



Comment: BENDING MACHINE

Bend tube as per Dwg D350-748-241 using CNC bender program D350A and Folio FT

DD 7-3-15

14.0

QC6

DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

07/03/21 ①

15.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Remove all marks from tube within limits of D350-748-241

2-Drill Tube as per Dwg D350-748-241 Using DT8876 Drill Jigs,
Set-up drill table as per QSI 010

3-Deburr

4-Engrave Part # and Batch # as per Dwg D350-748-241

Jb 7-4-16

45 02-05-01

16.0

QC6

DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

07/05/08

17.0

OUTSIDE SERVICE

OUTSIDE SERVICES



Comment: Sub-Contracting OUTSIDE SERVICES

Issue P/O: 3730

Stress relief at 375° for 5 hours

Magnetic Particle Inspect per ASTM E1444

Cadium Plate per QQ-P-416F, Class 1, Type 2

CL 07/05/09

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

Date: Tuesday, 12/5/2006 8:13:11 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: X-TUBE AS 350/355 HI AFT

Job Number: 29765A

Part Number: D350748241

Job Number:



Seq. #:

Machine Or Operation:

Description :

Embrittle relief at 375° for 8 hours, Chromate Treat
Possible Supplier: Southwest United Industries
Ensure Certificate of Conformity is attached

18.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Receive & Inspect For Transit Damage
Ensure certificate of conformity is attached

07-06-04

19.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

07-06-04

20.0

SPRAY PAINTING

SPRAY PAINTING



Comment: SPRAY PAINTING

1-Prime inside crosstube as per QSI 005 4.2

2-Paint Outside of Tube as per Dart QSI 005 4.2

07-06-06

21.0

QC14

Inspect Spray Paint



Comment: Inspect Spray Paint

Then, Wrap in plastic bag to protect from scratches

07-06-09

22.0

D35021

SUPPORT



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

SUPPORT

Batch: *28476*

07-06-13

23.0

D2856400

Abrasion Strip



Comment: Qty.: 1.2401 f(s)/Unit Total: 1.2401 f(s)

Abrasion Strip 7.10" long x2

Batch: *32020*

07-06-13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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NOTE: Date & initial all entries

Date: Tuesday, 12/5/2006 8:13:11 AM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: X-TUBE AS 350/355 HI AFT

Job Number: 29765A

Part Number: D350748241

Job Number:



Seq. #:

Machine Or Operation:

Description :

24.0

ALS41032225

Insert



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Insert

Batch: 19393

RT 07-06-13

25.0

AN960JD10

Washer



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Washer

Batch: 104118

RT 07-06-13

26.0

MS2192020

Clamp (per MIL-DTL-8783C)



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Clamp (per MIL-DTL-8783C)

Batch: 102712

RT 07-06-13

27.0

MS27039110

Screw



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Screw

Batch: 18836

RT 07-06-13

28.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Install Ground wire Insert, then insert screw and washer

2-Install Abrasion strips as per Dwg D350-748-241 & QSI 035.

3-Install supports Using Dt8876 as per Dwg D350-748-241, Torque to 60-80 IN-LBS

RT 07-06-13

29.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

2006-1-40

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

Date: Tuesday, 12/5/2006 8:13:11 AM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: X-TUBE AS 350/355 HI AFT

Job Number: 29765A

Part Number: D350748241

Job Number:



Seq. #:

Machine Or Operation:

Description :

30.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D350-748-241

Location: _____

PPP Rev: _____

31.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



W. A. Doherty

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

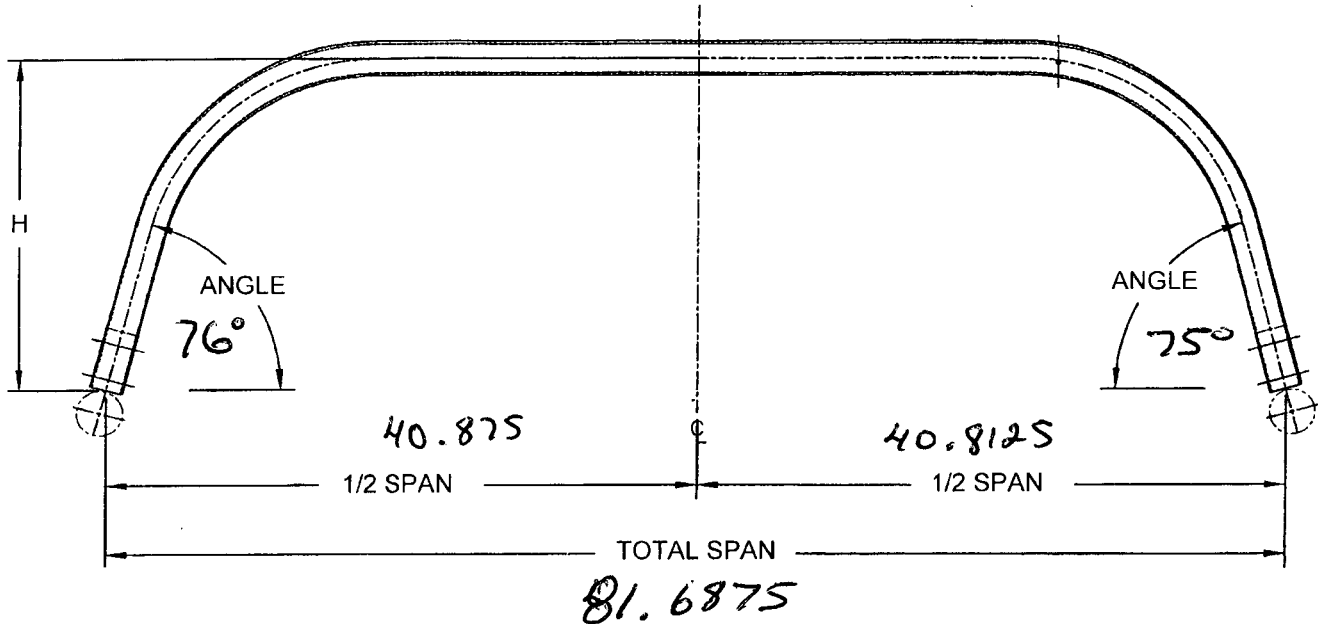
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QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Crosstube Bend Dimension Sheet



PART NUMBER: 350 748 241

BATCH NUMBER: 29765A

DRAWING: 350 748 241 REVISION: A

H: 31.35

1/2 SPAN: 40.9

TOTAL SPAN: 81.9

ANGLE: 75°

QC 15: M
DATE: 07/03/21
QTY: 0



DESIGN 9P	DRAWN BY 9P	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED H	APPROVED H	DRAWING NO. D350-748-241	REV. D SHEET 1 OF 3
DATE 06.10.31		TITLE CROSSTUBE (AS 350/355 HI AFT) SCALE NTS	
A	06.03.31	NEW ISSUE	
B	06.06.30	ADD D6018-125 & PRIME AND PAINT	
C	06.08.14	ADD CAD PLATING	
D	06.10.31	MAG. PARTICLE AND CAD PLATE AS MFD.	

RELEASED

06.10.31 H

QTY	P/N	DESCRIPTION
X	D350-748-241	CROSSTUBE ASSEMBLY (AS 350/355 HI AFT)
1	D6018-125	CROSSTUBE (OR D6015-125)
2	D3502-1	SUPPORT
2	D2856-400-710	ABRASION STRIP
1	AELS-1032-225	INSERT
1	AN960JD10	WASHER
2	MS21920-20	CLAMP (PER DART SPEC. M-MS21920-20)
1	MS27039-1-10	SCREW

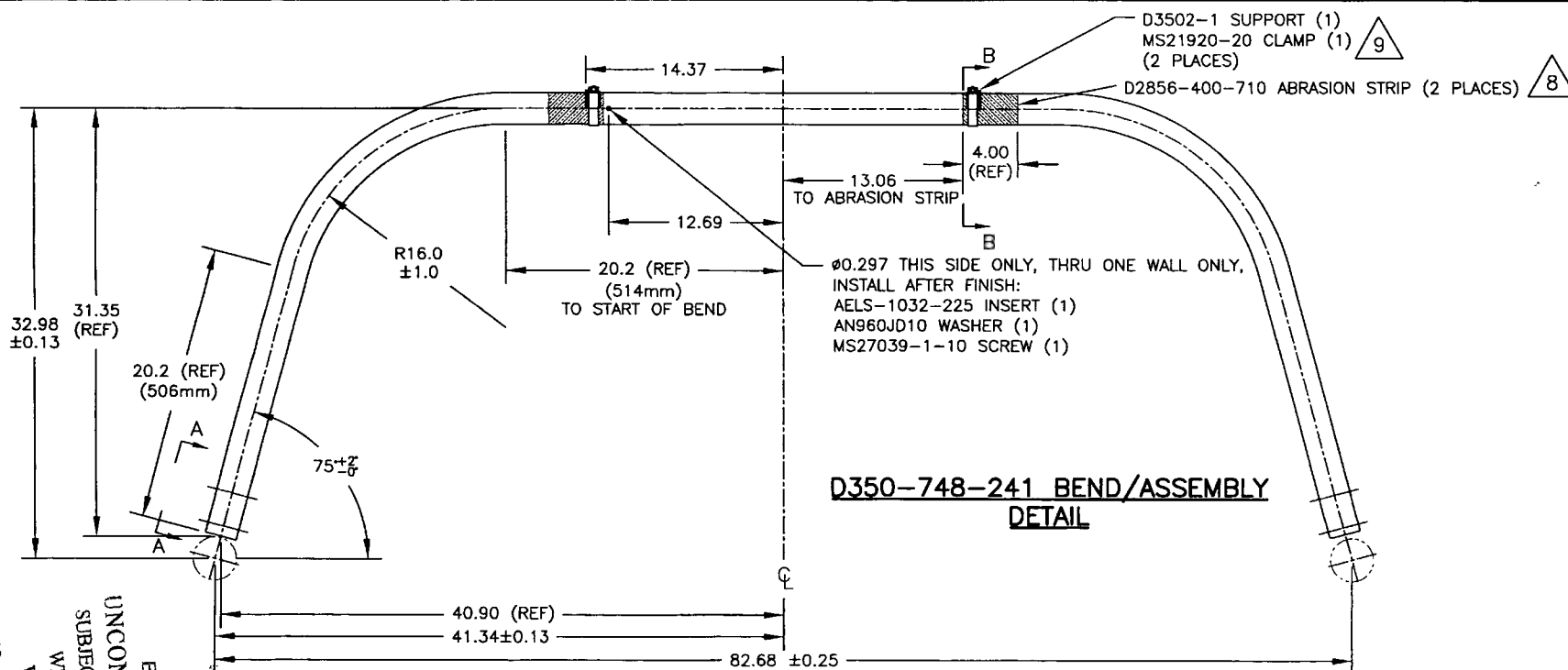
D350-748-141 CROSSTUBE:

- 1) MATERIAL: MANUFACTURED FROM D6018-125 OR D6015-125
FINISHED LENGTH = 122.70 ± 0.06
- 2) MACHINE PER MACHINING DETAIL ON PAGE 3. BLEND OUT ALL EDGES FROM MACHINING LONGITUDINALLY, TRANSITIONS SHOULD BE SMOOTH. NOTE: ALL HOLES ARE DRILLED AFTER BENDING.
- 3) SCRIBE DART PART NUMBER AND BATCH NUMBER IN THIS AREA WITH VIBRATING STYLUS.
- 4) BEND PROGRESSIVELY WITH A MINIMUM OF 7 PASSES. MAXIMUM TUBE FLATTENING DUE TO BENDING IS 6% BASED ON O.D.
- 5) HEAT TREAT TO MIN. 180 KSI PER MIL-T-6736 OR AMS 2759-1C AFTER TURNING
- 6) FINISH: MAGNETIC PARTICLE INSPECT PER DART QSI 038 4.2
CADMIUM PLATE PER AMS-QQ-P-416B, CLASS 1, TYPE II
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2
PAINT OUTSIDE PER DART QSI 005 4.2
- 7) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE. WHEN DRILLING HOLES EXTREME CARE MUST BE TAKEN AND CAREFUL DEBURRING PERFORMED TO ENSURE A CLEAN HOLE WITH NO CRACKING/CHIPPING/GROOVES.
- 8) INSTALL D2856-400-710 ABRASION STRIP WITH A GAP ON BOTTOM SIDE OF CROSSTUBE, CENTERED OPPOSITE D3502-1 SUPPORT, PER QSI 035.
- 9) TORQUE MS21920-20 CLAMPS 60 TO 80 IN-LB
- 10) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 11) ALL DIMENSIONS ARE IN INCHES
- 12) PART IS SYMMETRIC ABOUT CENTERLINE EXCEPT FOR $\varnothing 0.297$ HOLE.

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ENGINEERING
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 29765A

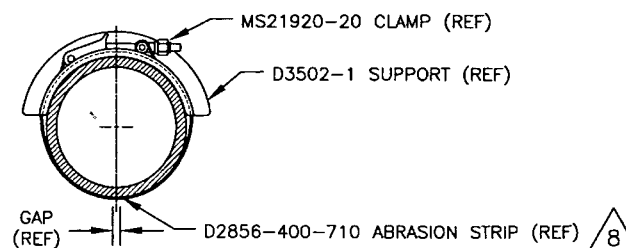
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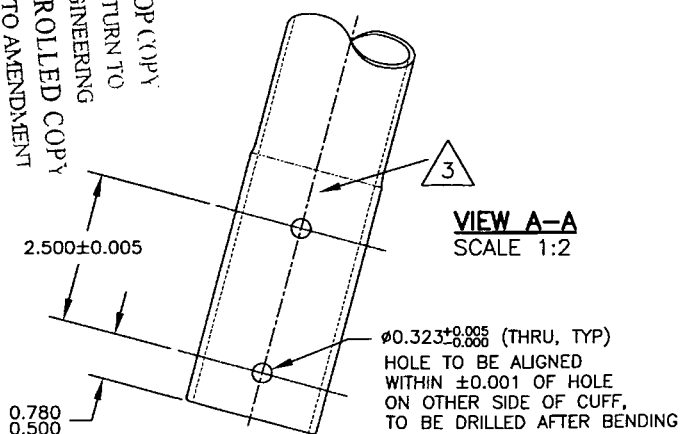


D350-748-241 BEND/ASSEMBLY DETAIL

SECTION B-B SCALE 1:2



VIEW A-A SCALE 1:2



WORK ORDER
NO. 29765A
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
RETURN TO
ENGINEERING

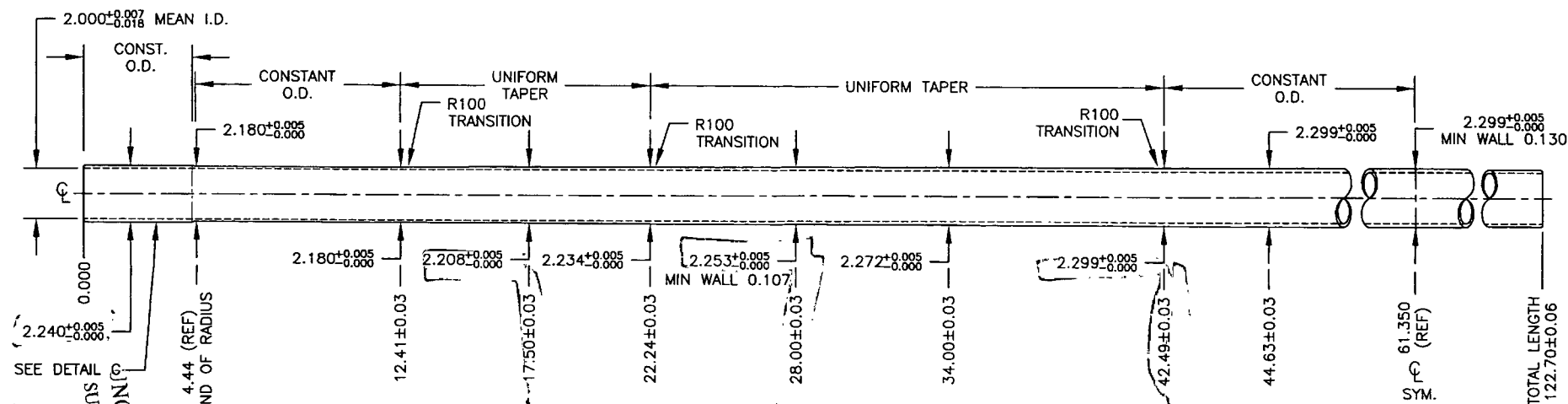
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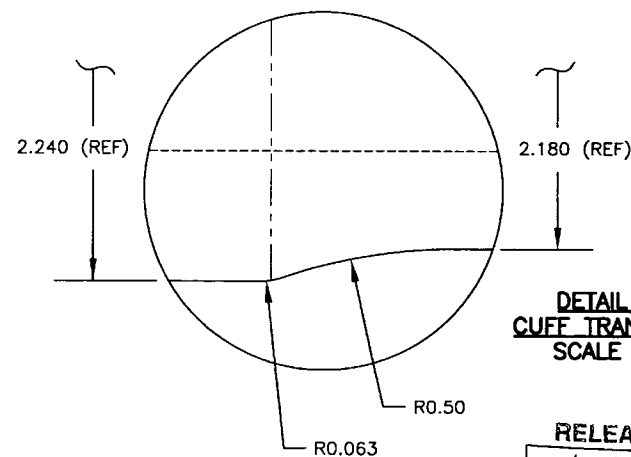
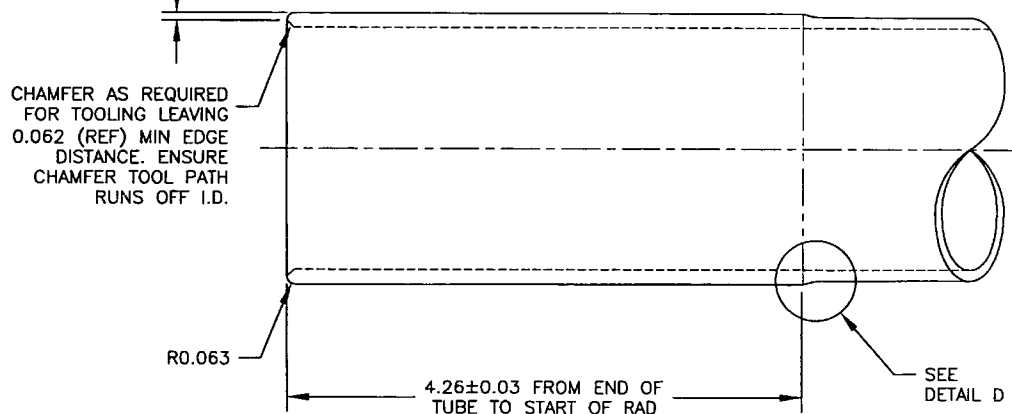
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DESIGN	qo	DRAWN BY	qo	DART	DART AEROSPACE LTD. HAMMERSLEY, ONTARIO, CANADA
CHECKED	#	APPROVED	#	DRAWING NO.	REV. D
DATE	06.10.31	TITLE	CROSSTUBE (AS 350/355 HI AFT)	D350-748-241	SHEET 2 OF 3
		SCALE	1:8		



D350-748-241 MACHINING DETAIL

DETAIL C: CUFF
SCALE 1:1



DETAIL D:
CUFF TRANSITION
SCALE 9:1

RELEASED

06.10.31

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DESIGN qp	DRAWN BY qp	DART	DART AEROSPACE LTD. WARRIMUR, ONTARIO, CANADA
CHECKED #	APPROVED #	DRAWING NO. D350-748-241	REV. D SHEET 3 OF 3
DATE 06.10.31	TITLE CROSSTUBE (AS 350/355 HI AFT)	SCALE 1:4	

DART AEROSPACE LTD		Work Order:
Description: Crosstube Assembly		Part Number: D350748241
Inspection Dwg: D350-748-24 Rev: C		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Inspection Sheet Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
SIDE A	2.240	+0.005 -0.000	2.212	/		
	2.180	+0.005 -0.000	2.185	/		
	2.208	+0.005 -0.000	2.211	/		
	2.234	+0.005 -0.000	2.237	/		
	2.253	+0.005 -0.000	2.256	/		
	2.272	+0.005 -0.000	2.276	/		
	2.299	+0.005 -0.000	2.302	/		
	.063	+0.010 -0.000	.063	/		
	R.50	+0.010 -0.000	.500	/		
	4.26	+0.030 -0.000	4.26	/		
SIDE B	2.240	+0.005 -0.000	2.241	/		
	2.180	+0.005 -0.000	2.184	/		
	2.208	+0.005 -0.000	2.211	/		
	2.234	+0.005 -0.000	2.238	/		
	2.253	+0.005 -0.000	2.256	/		
	2.272	+0.005 -0.000	2.276	/		
	2.299	+0.005 -0.000	2.301	/		
	.063	+0.010 -0.000	.063	/		
	R.50	+0.010 -0.000	.500	/		
	4.26	+0.030 -0.000	4.26	/		
	122.7	+0.06 -0.00	122.7	/		

Measured by: BG	Audited by: J.G	Prototype Approval:	N/A
Date: 06.12.08	Date: 06/12/08	Date:	N/A

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

DART AEROSPACE LTD		Work Order:	
Description: Crosstube Assembly (AS350/355 High Aft)		Part Number:	D350-748-241
Inspection Dwg: D350-748-241 Rev: C		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ **First Article**
☐ **Prototype**

	Inspection Sheet Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
SIDE A							
SIDE B							

Measured by:		Audited by:	
Date:		Date:	

Prototype Approval:	N/A
Date:	N/A

Rev	Date	Change	Revised by	Approved
A		New Issue (P/O D350-748-201)	KJ/JLM	



VAC AERO
INTERNATIONAL INC.

RELEASE NO

GST No. : R105468102

OAK 82647-1



HEAD OFFICE
1371 SPEERS ROAD, OAKVILLE, ONTARIO
CANADA L6L 2X5
TEL: (905) 827-4171 FAX: (905) 827-7489



2009 WYECROFT ROAD, UNIT B
OAKVILLE, ONTARIO
CANADA L6L 6J4
TEL: (905) 827-7377 FAX: (905) 827-1380



QUEBEC DIVISION
7450 RUE VÉRITÉ STREET, ST. LAURENT, QUÉBEC
CANADA H4S 1C5
TEL: (514) 334-4240 FAX: (514) 334-6269

01/11/2007

MM/DD/YYYY

PAGE : 1

BILL TO: 1DAR01
DART AEROSPACE LTD.
1270 ABERDEEN ST.
HAWKESBURY, ON

SHIP TO: DART AEROSPACE LTD.
1270 ABERDEEN ST.
HAWKESBURY, ON

K6A 1K7

K6A 1K7

DATE SHIPPED	SHIP VIA	F.O.B.
01/11/2007	EPIC EXPRESS	ORIGIN
CUSTOMER P/O No.	JOB No.	TERMS
PO00002725		COD

PART No.	DESCRIPTION	UOM	QTY ORD	QTY SHPD	TEST RESULTS
D350-CROSS TUBES D350-748-141-241		EA	8	8	
<p>Process Specifications: Procedure: 4353 HEAT TREATED TO 180-200 KSI PER AMS 2759-1C 100% HARDNESS TESTED PER ASTM E-18 HRC 40-43 MATERIAL: 4130</p> <p>REF. PS# 59054 RE: B29758A, B29757A, B29760A, B29765A, B29761A, B29764A, B29763A, B29762A</p>					
<p>100% HARDNESS TESTED 8 pcs. 42/43 HRC</p> <p>VA.I.O. TH. 25 Q.C.</p> <p>02/11/29</p>					

I hereby certify that the material covered by this release note has been inspected and tested and conforms to all specifications relevant thereto in accordance with the conditions of the contract / or purchase order.

ON BEHALF OF VAC AERO INTERNATIONAL INC



Sandra Sherman
Authorized Q.C. Inspector



VACUUM BRAZING · HEAT TREATING · SPECIAL PROCESSING · FURNACE EQUIPMENT
TURBINE COMPONENT OVERHAUL · PLASMA AND OTHER COATINGS



HEAT
TREATING

Packing Slip



Cadorath Plating Co. Ltd.

2150 Logan Avenue, Winnipeg, Manitoba R2R-0J2

Phone: (204) 633-9420 Fax: (204) 633-8033

INVOICE NUMBER:

34601

Sold To:

Dart Aerospace Ltd.

1270 Aberdeen St.

Hawksbury, ON K6A 1K7

ShipTo:

Net 2% Interest Per Month charged on Overdue Accounts.

Any claims for shortages, overcharges, or damaged goods must be made within seven (7) days from receipt of goods.

Customer Order #:	Date Received:	Terms:	G.S.T. #:	Ship Via:	Ship Date:
3730	May-15-2007	NET 30 DAYS	10071 6547 RT0001		May-29-2007

Item # Qty P/N & Description

1	1 EA SKID	S/N B31013A
	P/N D350748141	W/O 67187
2	1 EA SKID	S/N B31014A
	P/N D350748141	W/O 67188
3	1 EA SKID	S/N B31016A
	P/N D350748141	W/O 67189
4	1 EA SKID	S/N B29762A
	P/N D350748241	W/O 67190
5	1 EA SKID	S/N B29764A
	P/N D350748241	W/O 67191
6	1 EA SKID	S/N B29765A
	P/N D350748241	W/O 67192

**CERTIFICATE OF
CONFORMANCE**

**CADORATH PLATING CO. LTD.
2150 LOGAN AVENUE
WINNIPEG, MANITOBA R2J-0J1**

DATE: May-29-2007

CONSIGNEE TO: Dart Aerospace Ltd.
1270 Aberdeen St.
Hawksbury, ON K6A 1K7

W/O #: 67192
INVOICE #: 34601

**CONTRACT OR
PURCHASE ORDER #**

3730

DESCRIPTION: SKID

QTY 1

P/N # D350748241

S/N # B29765A

CADMIUM PLATE IAW AMS-QQ-P-416 TYPE 2 CLASS 1. MPI IAW
ASTM-E-1444. BAKE HEAT CHARTS #7795, #7797, #7838.

CERTIFICATE: I certify that the items indicated here on have
been inspected and tested and conform to all specifications
and requirements detailed on the contract or purchase order.

Approved Inspector:

William Maruszynski

